

Date: Thursday, 5/3/2007 11:37:28 AM
 User: Kim Johnston

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BALL
 Job Number : 32190
 Estimate Number : 12508
 P.O. Number : N/A
 This Issue : 5/3/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 28359
 Written By :
 Checked & Approved By :
 Comment : EST A 06.08.21 NEW ISSUE EC

Part Number : D35211
 Drawing Number : D3521 UNDER REVIEW CB
 Project Number : N/A
 Drawing Revision : UNDER REVIEW
 Material : N/A
 Due Date : 5/28/2007
 Qty: 5 Um: 9 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Purchase Part Number: 9617K47

Supplier: MCMASTER

Certificate of conformity is required

pull from stock

B. 24532

MS 07/05/11

2.0 9617K47 BALL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
 BALL

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QSS DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Note: Existing stock hole size is too small.
 Hole must be drilled out and tapped
 as per attached dwg CB
 07.05.04

1- Drill & Tap hole as per dwg D3521 using indexing fixture.

2- Deburr & polish, ensure no flat spot created from clamping.

3- Install Heli-coil.

MS 07/05/28

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL

Job Number: 32190

Part Number: D35211

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS21209F115	HELI COIL
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELI COIL

batch: m104194

M8 07/05/28

9

7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 07/05/28

9

8.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

B6 07-05-28

9

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/5/29 (9)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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(9)

Comment: FINAL INSPECTION/W/O RELEASE

7/5/29

Job Completion



u 8-5-29

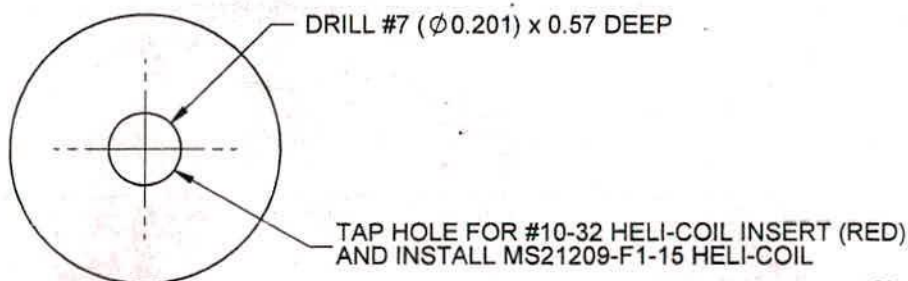
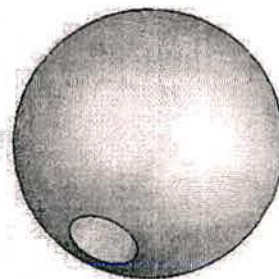
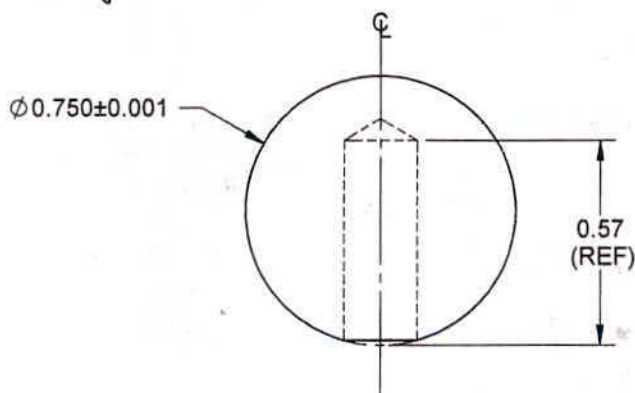
ELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3521	REV. A SHEET 1 OF 1
DATE 07.01.10		TITLE BALL	SCALE 2:1
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

UNDER REVIEW

07.05.04 (D)

dwg not released



D3521-1 BALL

NOTES:

- 1) MATERIAL: BRASS $\phi 0.75$ BALL (CAN MAKE FROM McMASTER-CARR P/N 9617K47)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015
- 6) PART IS SYMMETRIC ABOUT ϕ

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32190

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